

Work Order ID 114828

March-13-14 2:27:48 PM

114828

Page 1

Item ID: D4804-1

Revision ID:

Item Name: Strut

Start Date: 24/03/2014 Start Qty: 1.00

Required Date: 28/03/2014 Req'd Qty: 1.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***Stop ***NR2***

QC1

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4804

Rev A *[Signature]*

100

100

Doosan

Doosan Lathe

DOOSAN LATHE

Memo

1- Turn as per Folio FB274

Rev: *NA* & Dwg D4804 Rev: *A*

2- Deburr

0.00

0.00

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

[Handwritten marks and stamps]

1 *6* *D4804* *13* *89* *14-3-16*

1 *6* *D4804* *13* *89* *14-3-16*

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Page 2

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Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

120

QC8- Inspect parts - second check

120

QC

Memo

Quality Control

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

0.00

0.00

0.00

0.00

0.00

0.00

DAS
25
9-89

14-3-17

62 14/03/19 ①

130

Outsource process - NDT per QSI038 4.1

130

Outsource2

Memo

Outsource process - NDT

ISSUE P/O: 23404

C OF C IS REQUIRED

140

Receive & Inspect for Damage & Mat'l Certs

140

Packaging

Memo

Packaging

1X SP14-3-19

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Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

Quality Control

0.00

160

Identify as per dwg & Stock Location: 5T123

0.00

160

Packaging

Memo

Packaging

0.00

170

QC21- Final Inspection - Work Order Release

0.00

170

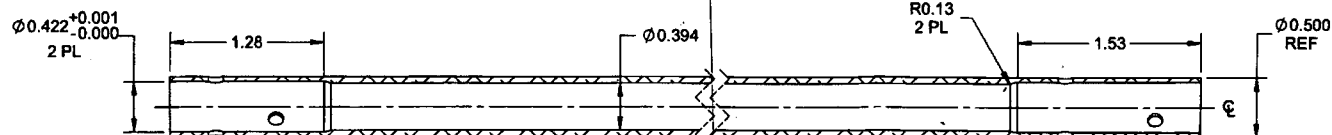
QC

Memo

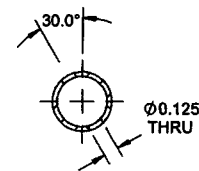
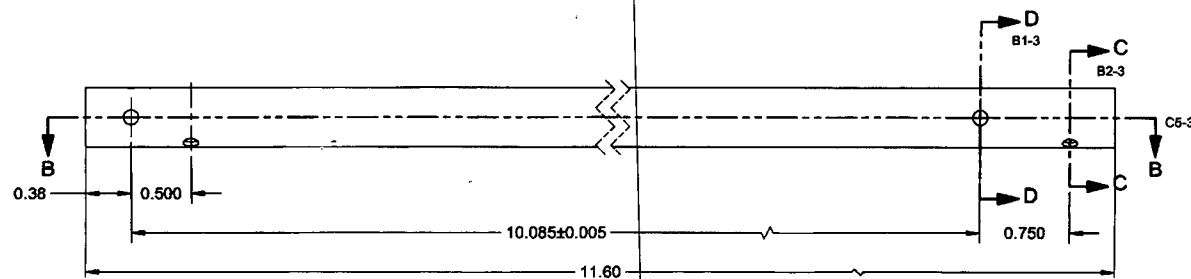
Quality Control

0.00

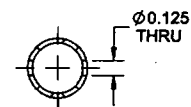
1
14-03-20
14-03-20
14-03-20



SECTION B-B B3-3



SECTION C-C C3-3
2 PL



SECTION D-D C4-3
2 PL

D4804-1 STRUT

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5843/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.23 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO. D4804	REV. A
MFG. APPR.	JLM		SHEET 3 OF 3
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	BIPOD ASSEMBLY, AFT	NTS
DATE	13.12.18	<small>COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

Page: 1 of 2

DOT APP 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO20271	Customer: Dart Aerospace Ltd.	Dept: NDT YUL	Reference: 23404
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN: 0	CSN: 0	TSO: 0	
Task: UNSCHEDULED			Sequence: 1

Work Required:

C/O NDT INSPECTION (LPI) ON 6 CROSSTUBES AND 18 MICS PARTS

ID#: D206-667-207BL AFT MID HEIGHT CROSSTUBE (QTY 4)

1 - WORK ORDER ID#: 114434

2 - WORK ORDER ID#: 114435

3 - WORK ORDER ID#: 114436

4 - WORK ORDER ID#: 114437

ID#: D206-667-207 AFT MID HEIGHT CROSSTUBE (QTY 2)

5 - WORK ORDER ID#: 114548

6 - WORK ORDER ID#: 114549

ID#: D4884-1 END FITTING, EYE (QTY 4): 7 - WORK ORDER ID#: 111341

ID#: D4834-1 STRUT (QTY1): 8 - WORK ORDER ID#: 112132

ID#: D4804-1 STRUT (QTY1): 9 - WORK ORDER ID#: 114828

ID#: D4801-1 STRUT (QTY1): 10 - WORK ORDER ID#: 112151

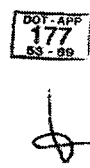
ID#: D4837-1 STRUT (QTY1): 11 - WORK ORDER ID#: 112135

ID#: D4836-1 STRUT (QTY1): 12 - WORK ORDER ID#: 112134

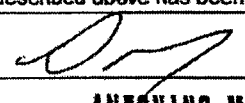

ID#: D4834-2 STRUT (QTY1): 13 - WORK ORDER ID#: 112133

ID#: D4835-1 STRUT (QTY2): 14 - WORK ORDER ID#: 114816

ID#: D3011-1 RAPPEL (QTY6): 15 - WORK ORDER ID#: 114306

Action Taken:	Date:	Initial/Stamp:
LPI CARRIED OUT ON ITEMS LISTED ABOVE (ITEMS 1-15) IAW ASTM1417M-13 NO CRACK FOUND Pen: ZL-56 BATCH# 09H094 EXP. DATE: AUG 2014, DEV: SKD-S2 EXP. DATE: OCT2017 CLEANER: SKC-S EXP. DATE: APR 2018	MAR 18 2014	

that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

 ANTONINO MARCHETTA	ACA/SCA Stamp 	Date: MAR 18 2014
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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO23404**

Purchase Order Date 3/18/2014

PO Print Date 3/19/2014

Page Number 2 of 6

Order From :

VC-SKY001

SKYSERVICE
6120 MIDFIELD ROAD
MISSISSAUGA, ONTARIO L5P 1B1
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 905-678-5636

Ship To Contact

Ship To Phone

Ship Via: Delivered

Ship Acct:

Buyer

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

Line Total: \$80.

5	112132	D4834-1 STRUT	3/19/2014	1.00	\$80.40	\$80.
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Yes

3/19/2014

SAME AS ABOVE

Line Total: \$80.

6	114828	D4804-1 STRUT	3/19/2014	1.00	\$80.40	\$80.
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Yes

3/19/2014

SAME AS ABOVE

SP14-3-19.

Line Total: \$80.

7	112151	D4801-1 STRUT	3/19/2014	1.00	\$80.40	\$80.
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Yes

3/19/2014

SAME AS ABOVE

Line Total: \$80.

Note:

3/19/2014